Dart Aerospace Ltd. Tuesday, 8/28/2007 3:17:22 PM Kim Johnston User: **Process Sheet Drawing Name** : STRAP Customer : CU-DAR001 Dart Helicopters Services : 34291B Job Number **Estimate Number** : 10729 : NA : D23245 **Part Number** P.O. Number S.O. No. : HA : 8/28/2007 **Drawing Number**  D2324 REV C This Issue : N/A Prsht Rev. Project Number : SMALL /MED FAB : C **Drawing Revision** First Issue : 32872 : 1/2 : 9/12/2007 Material Previous Run Due Date Qty: 40 Um: Written By Checked & Approved By : Est. E 03/02.28 Reformat; Incorporated D2324-3 & D2324-5 K Comment J/RF **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: 1.0 M304S16GA 304/316 .063 Sheet Comment: Qty.: 0.0184 sf(s)/Unit Total: 0.7360 sf(s)304/316 .063 Sheet BH 105 130 FLOW WATER JET 20 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2324 Dwg Rev:\_ Prog Rev:\_ 2-Deburr if necessary 3.0 INSPECT PARTS AS THEY COME OFF MACHINE QC2 Comment: DIMENSIONAL CHECK Inspect dimensions per template D2324-5T1 4.0 QC8 SECOND CHECK

SMALL & MEDIUM FAB RESOURCE

Comment: SECOND CHECK

SMALL FAB 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

Each

40

## Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP		PRO	CEDURE CHANGE	В	y Dat	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		,						,		
		·		·						
Part No	:		PAR #:	Fault Category:	NCR: \	es No	DQA:	Date:	77705/18	

QA: N/C Closed: \_\_\_\_ Date: \_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Ammanal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector		
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NOTE: Date & initial all entries

Date: User\* Tuesday, 8/28/2007 3:17:22 PM

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRAP

Job Number: 34291B

Part Number: D23245

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Identify and Stock Location: \$\frac{1}{26}\$

7.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace	Ltd .								
W/O:			WC	ORK ORDER CH	ANGES					······································
DATE STEP		PR	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					•					
Part No	•	PAR #:	Fault Cate	gory:	NC	R: Yes I	No <b>DQ</b>	A:	_ Date: _	
						QA: N/	C Close	d:	_ Date: _	
NCR:			WORK ORD	ER NON-CONFO	RMANCE	(NCR	)		ı	
DATE	OTED	Description of NC	Corrective Action Se		Section B		Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	otion ———————	Sign & Date	Secti		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34291B
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

х	First Article	Prototy	ype
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Tolerance	Actual	Accept	Reject	Method of	Comments
	Dimension			inspection	
+/-0.030	RO.38			8-6	
+0.006/-0.001		/		Vern	
+0.005/-0.001	\$ 6.192			Vern	
+/-0.010				Vern	
+/-0.010	0.381			Vern	
+/-0.010	1.876	/		Vern	
+/-0.010	3,002			Vern	
+/-0.010	3.379			Vern	
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	+/-0.030 +0.006/-0.001 +0.005/-0.001 +/-0.010 +/-0.010 +/-0.010	Tolerance Dimension  +/-0.030	Tolerance Dimension Accept  +/-0.030	Tolerance Dimension Accept Reject  +/-0.030	Tolerance         Dimension         Accept         Reject         Inspection $+/-0.030$ $R0.38$ $R0.38$ $R0.258$

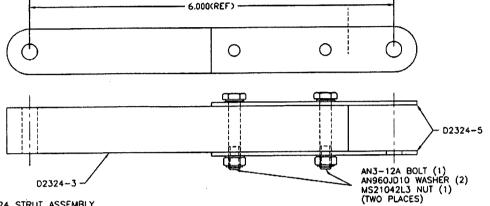
<b>A</b>				
Measured by:	Audited by:	to,	Prototype Approval:	N/A
Date: (1) 108/31	Date:	07/08/3/	Date:	N/A

Rev	Date	Change	Revised by	Approved	
Α	06.06.05	New Issue	KJ/JLM		
				$\overline{}$	

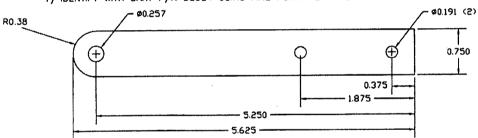


	DESIG	n /ILLIAMS	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
Ì	CHECH		APPROVED_	DRAWING NO.	REV. C
١		#	-#-	D2324 SHEET	1 OF 1
İ	DATE			TITLE	SCALE
	04.1	12.14		STRUT	
T	Α		94.11.08	NEW ISSUE	
	В		96.05.07	UPDATE MATERIALS	
	C		04.12.14	UPDATE NOTES	

RELEASED 04.12.16



D2324 STRUT ASSEMBLY 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75

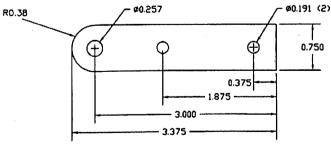
(REF DART SPEC. M6061T6B0.750X00.750)

ACID ETCH AND ALODINE PER DART QSI 005 4.1 2) FINISH:

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) 1) MATERIAL: (REF DART SPEC. M304S16GA)

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH:

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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